

# Work Order ID 50370



Page 1

July 13, 2009 12:28:17 PM

Item ID:	D3162-041	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Bracket Assembly					
Start Date:	7/15/09	Start Qty:	10.00		Cust Item ID:	
Required Date:	7/15/09	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan: <u>mf</u>	Date: <u>09-07-15</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3162	Rev C								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3162 <input checked="" type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2-								
	Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

⇒ 507/7/23

counter  
747

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50370

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Item ID: D3162-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Deburr break all unmarked sharp edges .005 to 0.010 [ ] Form as per drawing

☐

C'sink holes as per Dwg D3162

Small Fab

EB 09/07/23  
SP 07/07/23

(47)  
(47)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MR 09/07/23 (47X)

150

Small Fab

0.00



Small Fab

Memo

0.00

Assemble as per drawing

Small Fab

EP 09/07/23 (47)

135  
QC 5  
W

QC Inspection 2) 507/2/23 (47) <sup>counted</sup>

f

W/O: 50370		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
9/7/23		Permanent change Change step to the following: Small FAB { <ul style="list-style-type: none"> <li>- Debur</li> <li>- C-sink per Dwg.</li> <li>- Bend per Dwg.</li> </ul>	B	09.07.27			S 09/07/23	
		- QLS inspect to current spec - chemical coat as per Dwg. AC3 inspect glazing	B	09.07.27			S 09/07/23	

Part No: D3162-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 50370

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Item ID: D3162-041

Accept

Setup Start

Revision ID: C

Stop

Item Name: Bracket Assembly

Start Date: 7/15/09 Start Qty: 10.00

Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 73

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



QC

Quality Control



Packaging

Packaging



QC

Quality Control

⇒ S 07/15/23

counted  
x12 φ

R 9/12/24 (42)

09/10/27

w 09-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 50370

Parent Item: D3162-041RevC

Parent Item Name: Bracket Assembly


Comments:

Start Date: 7/15/09


Required Date: 7/15/09

Start Qty: 10.00


Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			150	sf	135.5726	0.0758			
												
6061-T6 .063 Sheet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	135.5726316	
109463	1	
110551	134.572632	

MS20426AD3-3		Purchased	No			100	Each	8,433.000	20.0000			
												
RIVET CHANGE LENGTH PER GSI CAL 104.07.23												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8433	
104374	4433	
110398	4000	

MS21059L3		Purchased	No			150	Each	871.0000	10.0000			
												
Nut Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	871	
109962	371	
111925	500	

110551 B 9-7-22

EP 09/07/23

94

(47)

EP 09/07/23

47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

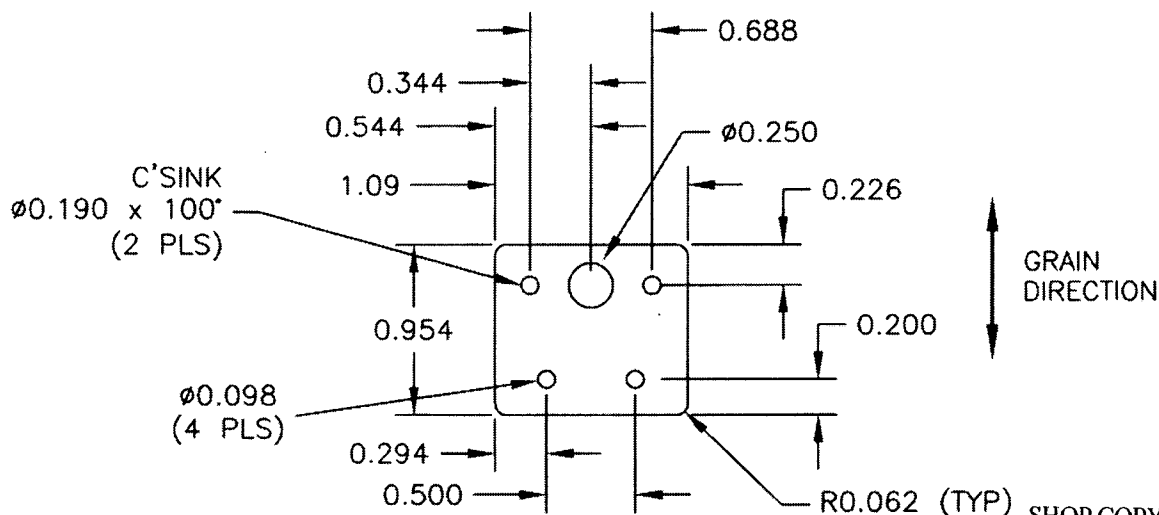
**NOTE:** Date & initial all entries





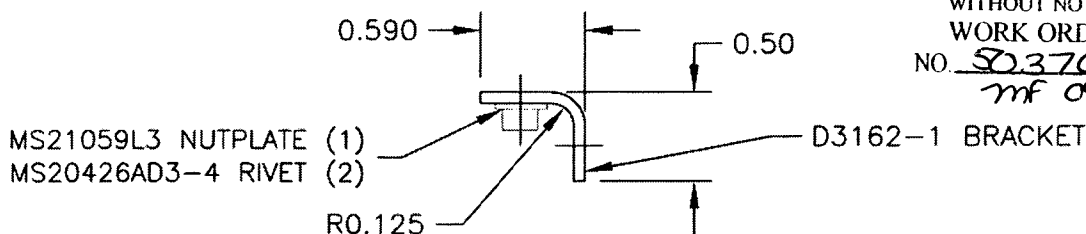
**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 1 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.10.05	ADD D3162-3/-4	

**RELEASED**  
05.12.01

**D3162-1F FLAT PATTERN**  
(USED TO MAKE D3162-1 BRACKET)

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50376  
mf 09-07-15



**D3162-041 BRACKET ASSEMBLY**

**NOTES:**

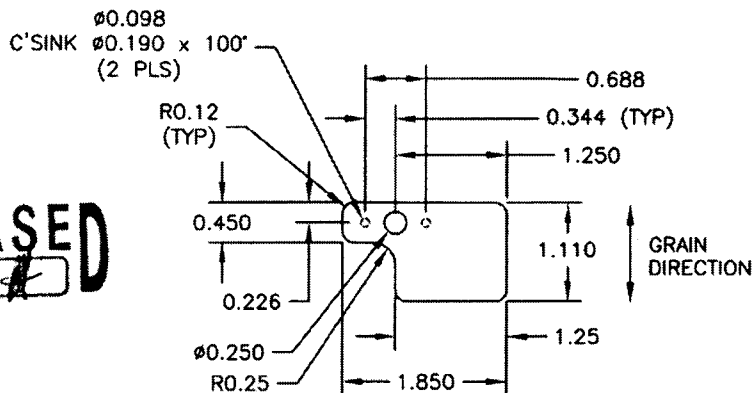
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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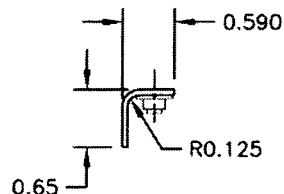
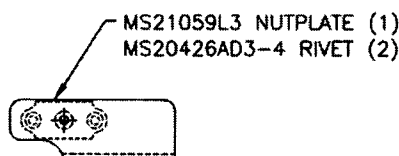
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**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 2 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
05.12.01

**D3162-3F FLAT PATTERN**  
(USED TO MAKE D3162-3/-4 BRACKETS)



**D3162-043 BRACKET ASSEMBLY (SHOWN)**  
**(D3162-044 BRACKET ASSEMBLY (OPPOSITE))**

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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NO. 50370  
*mf*  
09-07-15